

NON EUROCOPTER ASAP

Work Order ID 68080



Page 1

Wednesday, April 06, 2011 10:24:30 AM

Item ID:	D350-591-311	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Heli-Access-Step, Long LH					
Start Date:	4/5/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/5/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-04-14	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100		0.00							
	DOCUMENT CONTROL								
DC	<b>Memo</b>	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-311 CHG002		NON EUROCOPTER		<div style="display: flex; justify-content: space-between;"> <span>8/11/04/18</span> <span> CL 11-4-14</span> </div>				
110		0.00							
	Large Fab								
Large Fab	<b>Memo</b>	0.00							
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R <input type="checkbox"/> Aluminum Rod		<div style="display: flex; justify-content: space-between;"> <span>M114703</span> <span>M115928</span> </div>						
	3-Grind End Plate flush								

11-04-09 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D350-591-311

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Setup Start

Revision ID:

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Start Date: 4/5/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds  Memo	0.00  0.00				4	0	3611/04/12	
130 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				LH/ml	11	04 12 (4)	
140 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00				4 LH	0	11/04/12	

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Required Date: 4/5/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 BL 11-4-12

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R□□Aluminum Rod□ 1114703

6-Grind End Plate flush

7-Install last rivet as per Dwg.

11-04-213

4 φ

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				<u>4</u>			<u>11-04-14</u>
200  QC Quality Control	QCS- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>nl</u>	<u>11</u>	<u>04</u>	<u>14</u> (4)
210  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				<u>H.</u>	<u>BL</u>	<u>11-4-14.</u>	

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Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M116964.

Memo

0.00

START TIME: 10:30

OVEN TEMPERATURE: 320°

FINISH TIME: 11:00.

H.

BR 11-4-14.

230



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M1173100

0.00

Memo

0.00

464 M 11/04/15

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

S. M. 11/04/15

H.

LH

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Required Date: 4/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/4/11 42 \$

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8 11/4/11

x4  
44

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: \$

REUD

11/4/11 40 \$

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Required Date: 4/5/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/19

A 11/4/19

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Wednesday, April 06, 2011 10:24:36 AM

Page 1

Work Order ID: 68080

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH





Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified  
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011  Step Modification	416709	Manufactured	No				Each	1.0000		1 4		11/4/15	68082
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG020				1					
				65343				1					
D3272-1  Step		Manufactured	No			110	Each	0.0000	1	4		11.04.07	B68083(4)
D3067-1  End Plate		Manufactured	No			110	Each	29.0000	1	4		11.04.08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA016				29					
				65969				29					
D3219-1  Plate		Manufactured	No			110	Each	68.0000	2	8		11.04.08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				52					
				67580				52					
				WA017				16					
				66133				16					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, April 06, 2011 10:24:36 AM

Page 2

Work Order ID: 68080

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

D3066-1 Manufactured No

180 Each

66.0000

2

8



Spacer

Location

Loc Qty

Loc Code

WA015

66

66131

13

67581

53

MS20600-AD4W4

Purchased No

180 Each

1,280.000

16

64



Rivets

Location

Loc Qty

Loc Code

ST321

1275

116188

1275

WA018

5

116712

5

D3065-041

Manufactured No

180 Each

27.0000

1

4



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA014

27

66149

7

66808

20

D3067-1

Manufactured No

180 Each

29.0000

1

4



End Plate

Location

Loc Qty

Loc Code

WA016

29

65969

29

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Shop Packet Print

Page 2

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

AN3-35A Purchased No 250 Each 175.0000 2 18



Bolt

Location Loc Qty Loc Code

ST353 175

116191 75

117313 100

D3235-1 Manufactured No 250 Each 67.0000 2



Mounting Lug

Location Loc Qty Loc Code

ST471 67

65073 7

66941 60

D3278-041 Manufactured No 250 Each 55.0000 1



Support Assembly

Location Loc Qty Loc Code

ST471 55

66155 15

66946 40

AN960JD416 NAS1149D0463J Purchased No 250 Each 0.0000 16



Washer

AN960JD516 NAS1149D0563J Purchased No 250 Each 0.0000 4



Washer

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Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

AN5-36A

Purchased

No

250

Each

97.0000

2

8



Bolt

Location

Loc Qty

Loc Code

ST341

97

116704

97

Manufactured

No

250

Each

94.0000

2

8

D2618



Bushing

Location

Loc Qty

Loc Code

ST019

94

66942

94

Manufactured

No

250

Each

56.0000

4

16

D2230-3



Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST470

1

66936

1

ST476

51

66936

51

Manufactured

No

250

f

2.5200

1.2

4.8

D2856-400



Abraison Strip

Location

Loc Qty

Loc Code

ST409

2.52

63735

2.52

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

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Shop Packet Print

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Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

250

Each

2,051.000

-2



Nut

Location

Loc Qty

Loc Code

ST300

2051

116391

451

116540

800

116549

800



8  
11/4/11

AN4-13A

Purchased

No

250

Each

796.0000

-8



Bolt

Location

Loc Qty

Loc Code

ST357

796

117094

296

117313

500



32  
11/4/11

MS21042L5

Purchased

No

250

Each

849.0000

2



Nut

Location

Loc Qty

Loc Code

ST300

849

115594

89

116105

500

116548

260



8

MS21042L4

Purchased

No

250

Each

3,075.000

8



Nut

Location

Loc Qty

Loc Code

ST300

3075

116188

1075

116823

2000



32  
11/4/11

W/O:		WORK ORDER CHANGES					
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Required Date: 4/5/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD10 NAS1149D0363J Purchased

No

250

Each

0.0000

4

16



Sal

Washer

M116525

11/4/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD.</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

*07.06.04*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *48080*

*M/11-04-4*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

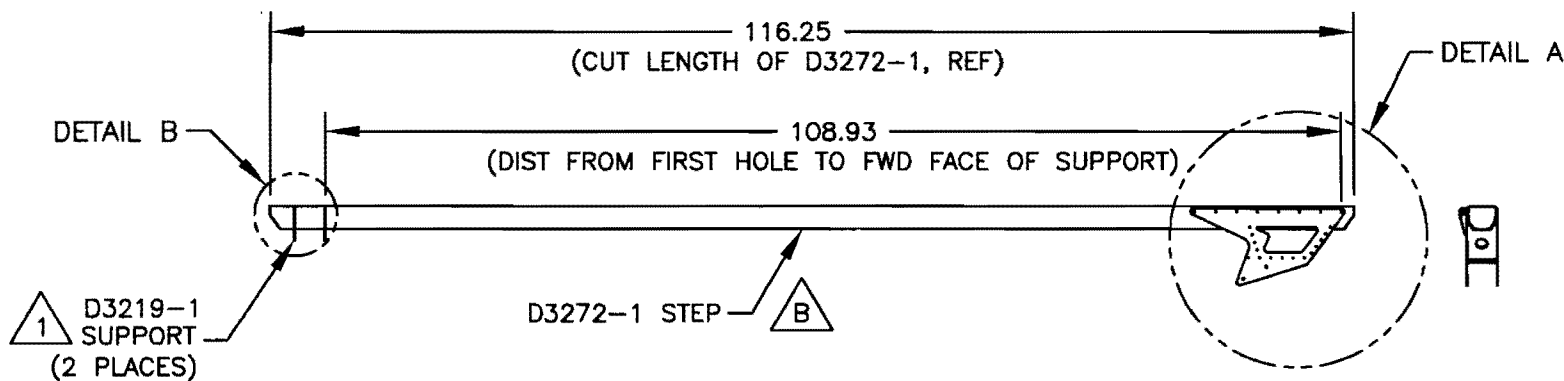
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

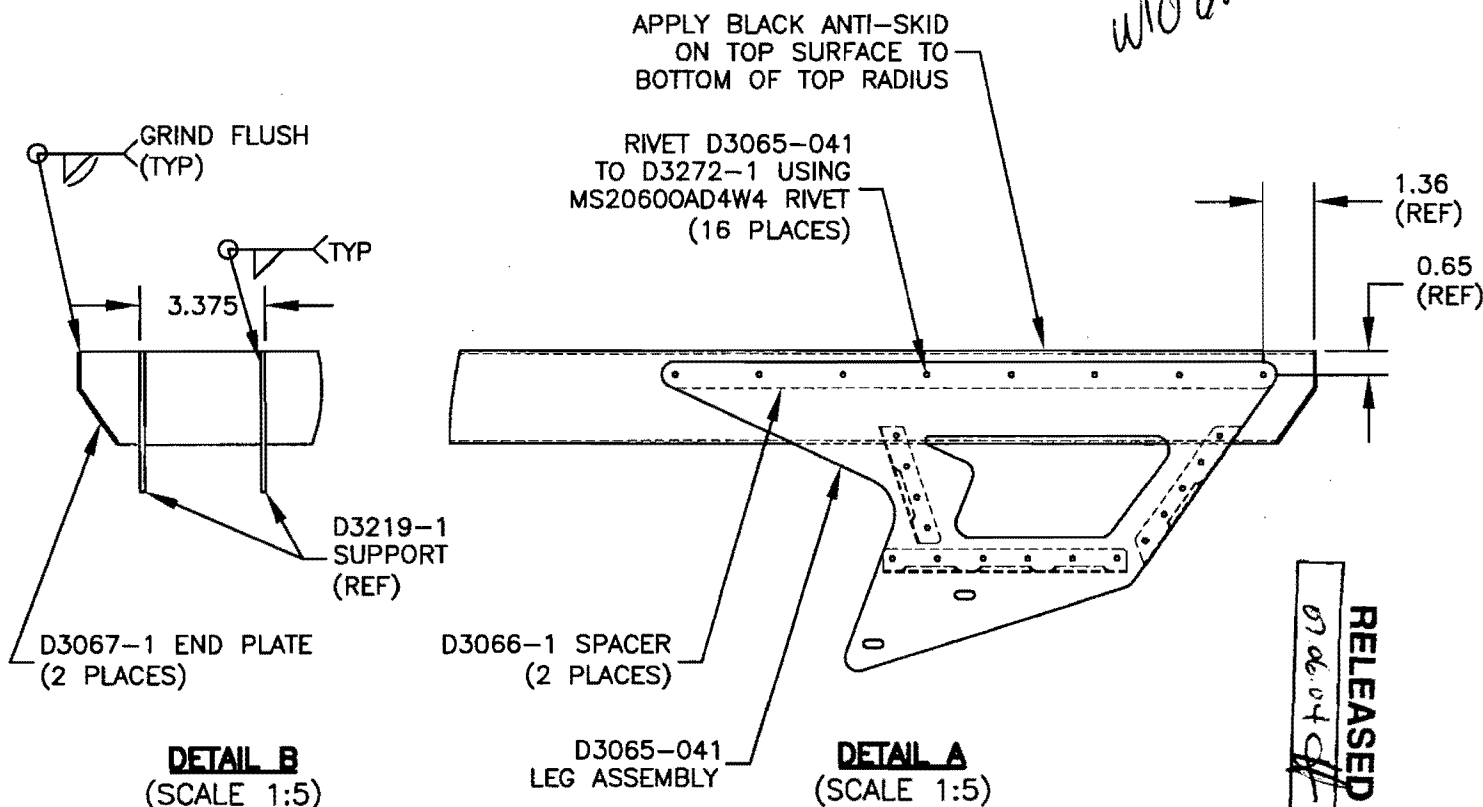
**NOTE:** Date & initial all entries

**DART**

DESIGN	90	DRAWN BY	10	DART AEROSPACE LTD
CHECKED	CE	APPROVED	10	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

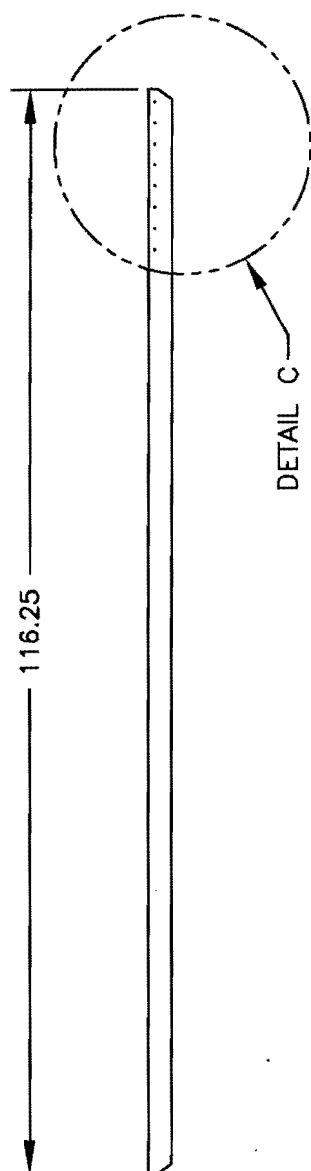
**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

RELEASED

07.06.04 *[Signature]*

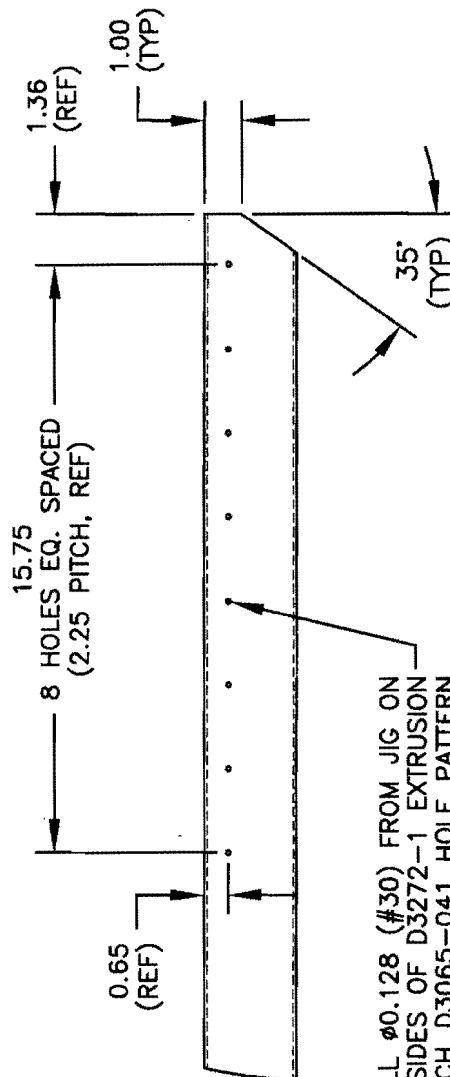


DETAIL C

**B D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

*080830/2*



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
	X							D350-591-212	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
		X						D350-591-213	<b>Heli-Access-Step™</b> , Short Step – High Skid, LH
			X					D350-591-214	<b>Heli-Access-Step™</b> , Short Step – High Skid, RH
				X				D350-591-215	<b>Heli-Access-Step™</b> , Short Step – Low Skid, LH
					X			D350-591-216	<b>Heli-Access-Step™</b> , Short Step – Low Skid, RH
						X		D350-591-311	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
							X	D350-591-312	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

